

Derev. 59282

Work Order ID 44634

June 26, 2009 10:52:56 AM



Item ID: D3499-042
Revision ID: B
Item Name: Cable Guard Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 4.00
Required Date: 03/08/2009 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: mf Date: 09/09/24 Tooling:
QC: Date: SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3499	Rev B

100	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3499								

10/05/18
F.F.

5

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10/05/26

45

Pto →
~~Last, Last Page~~

120	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

PP?

10-5-27

5x25

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

[illegible]

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/05/31 AJ

mk
10-5-28

June 26, 2009 10:52:56 AM

Page 1

[illegible]**Start Date:** 15/07/2009

Required Date: 03/08/2009

Start Qty: 4.00

Required Qty: 4.00

[illegible]

Date: Wednesday, 14/01/2009 8:35:04 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001- Dart Helicopters Services	Drawing Name : CABLE GUARD
Job Number : 44634	
Estimate Number : 12407	
P.O. Number :	Part Number : D3499042
This Issue : 14/01/2009 S.O. No. :	Drawing Number : D3499 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 43905	Material :
Written By :	Due Date : 30/01/2009 Qty: 5 Um: Each
Checked & Approved By : JLD 09.01.14	
Comment : Est Rev:A New Issue 06-05-05 JLM Est Rev:B As per Rev B 06-08-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34992	Mounting Plate
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

MOUNTING PLATE

Batch: 44635

2.0	D34993	Plastic Cable Guard
-----	--------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLASTIC CABLE GUARD

Batch: 41875 x 8 B43907 x 2

3.0	D34995	Placard
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLACARD

Batch: B41903 x 4 B44797 x 6

4.0	AN3C5A	Bolt
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M110985 x 6 M110916 x 4

5.0	AN3C6A	BOLT
-----	--------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: M110372

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/01/2009 8:35:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 44634

Part Number: D3499042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

washer

Batch: M-110915

88 09/03/31 (X5)

7.0

MS210433

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Batch: M-110562

88 09/03/31 (X5)

8.0

NAS1515H3L

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

WASHER

Batch: M-110806

88 09/03/31 (X5)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3499

88 10/05/13 + FIF

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

88 10/05/13

pto
Last Last
pae

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

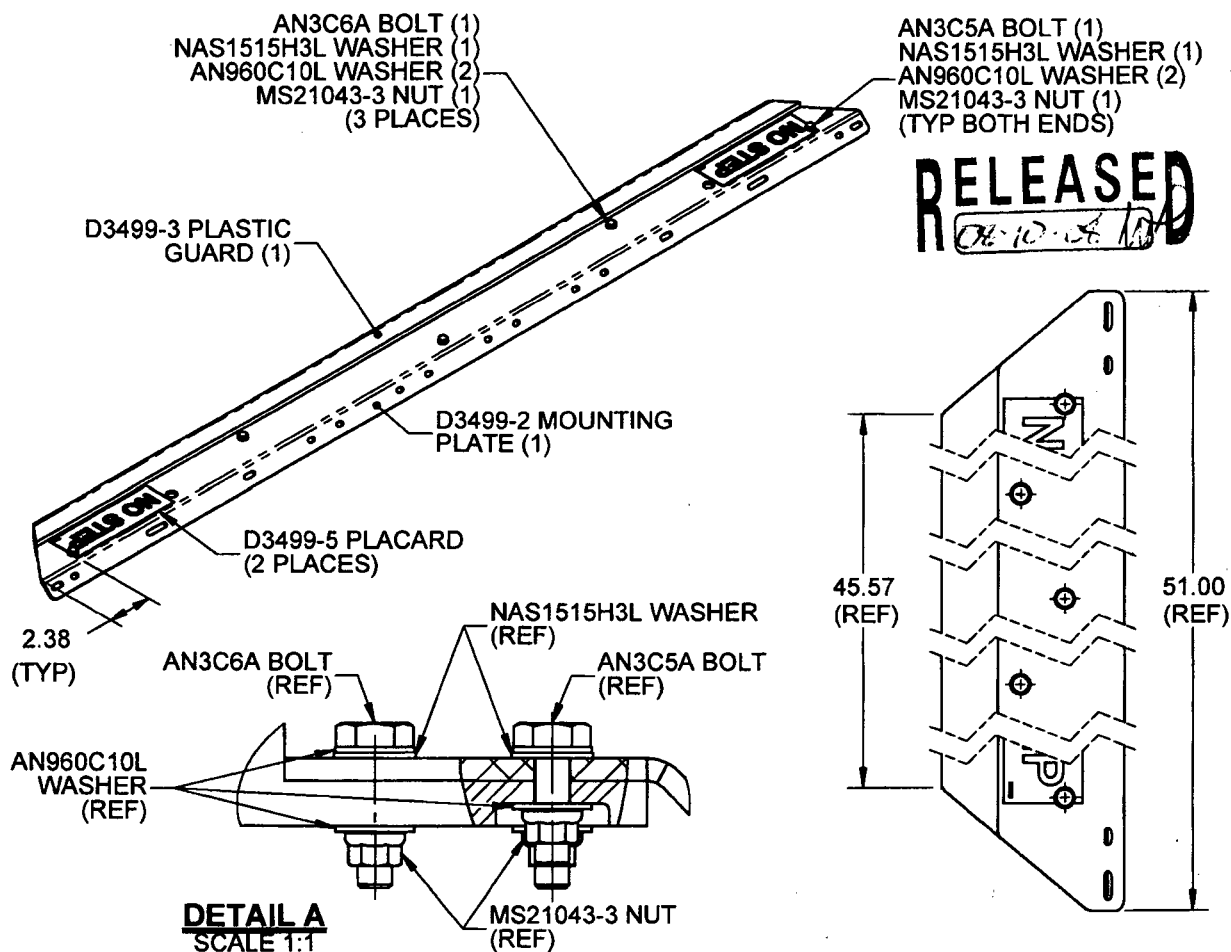
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

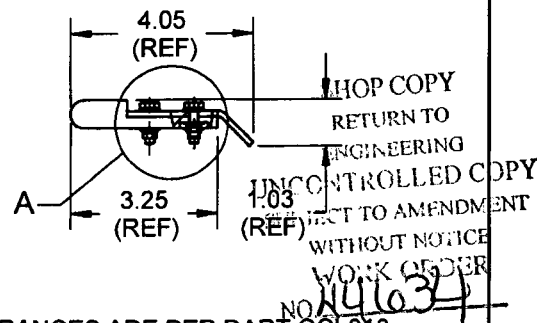
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 1 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4
A	06.04.11	NEW ISSUE	
B	06.08.15	RE-DESIGN D3499-2F/-3	

**D3499-042 CABLE GUARD ASSEMBLY**

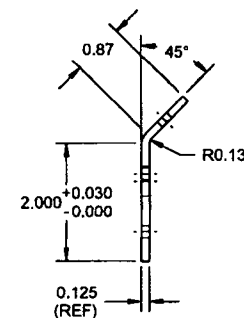
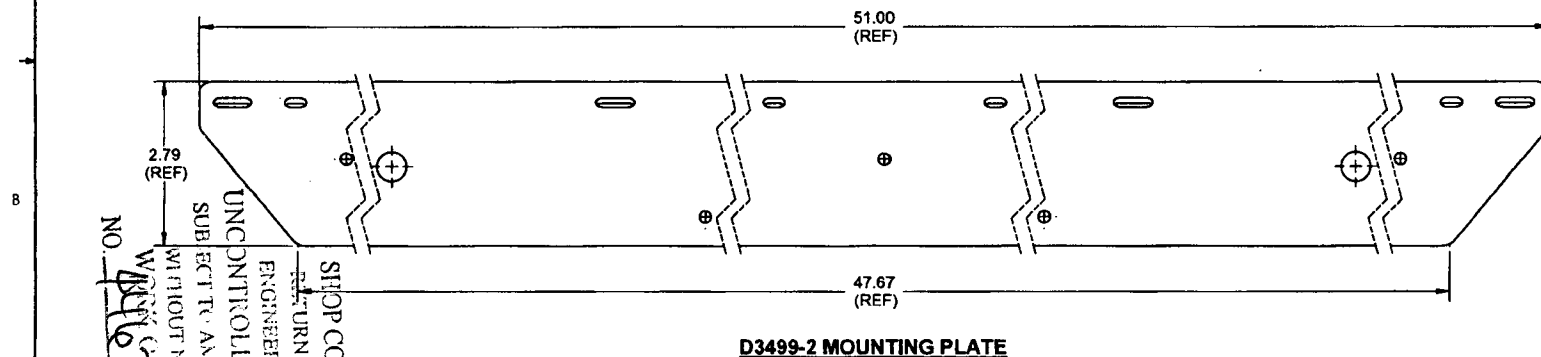
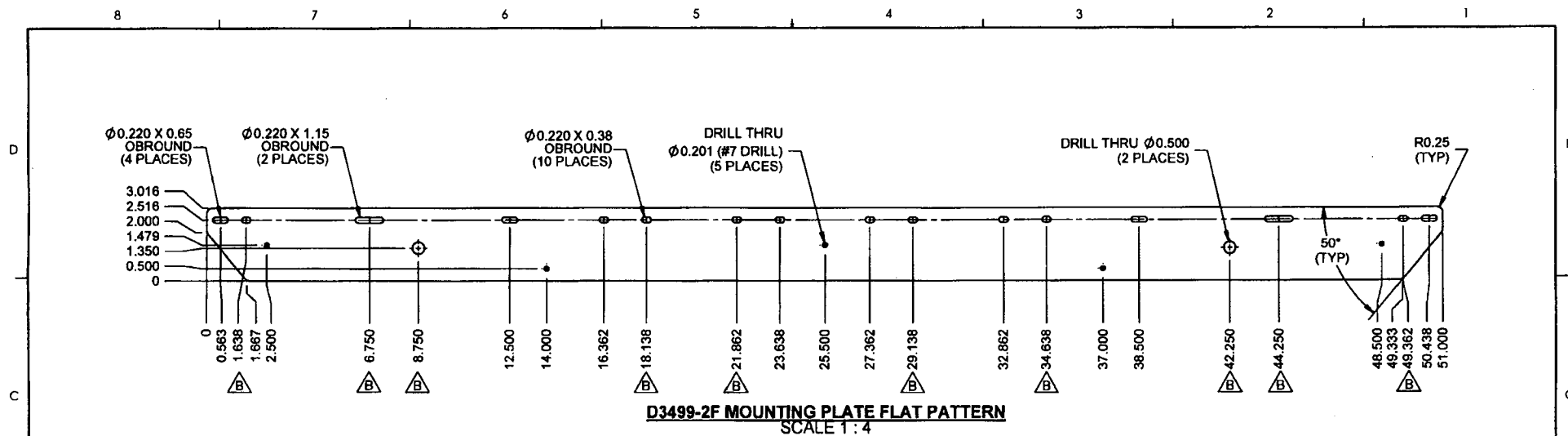
QTY -042	P/N	DESCRIPTION
X	D3499-042	CABLE GUARD ASSEMBLY
1	D3499-2	MOUNTING PLATE
1	D3499-3	PLASTIC GUARD
2	D3499-5	PLACARD
2	AN3C5A	BOLT
3	AN3C6A	BOLT
10	AN960C10L	WASHER
5	MS21043-3	NUT
5	NAS1515H3L	WASHER

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NOTES:

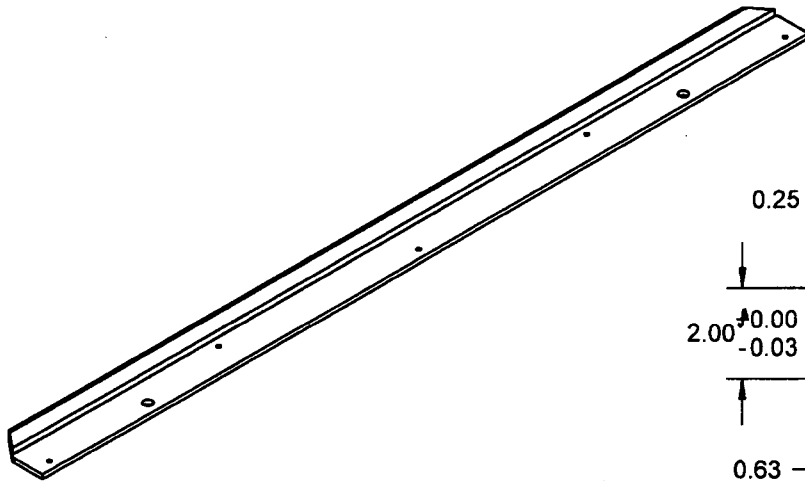
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M8061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
DS 10 08 11

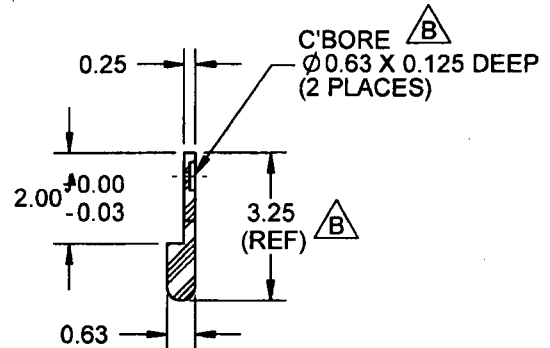
DESIGN 	DRAWN BY 	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D3499	REV. B SHEET 2 OF 4
DATE 06.08.15	TITLE CABLE GUARD	SCALE 1:2	
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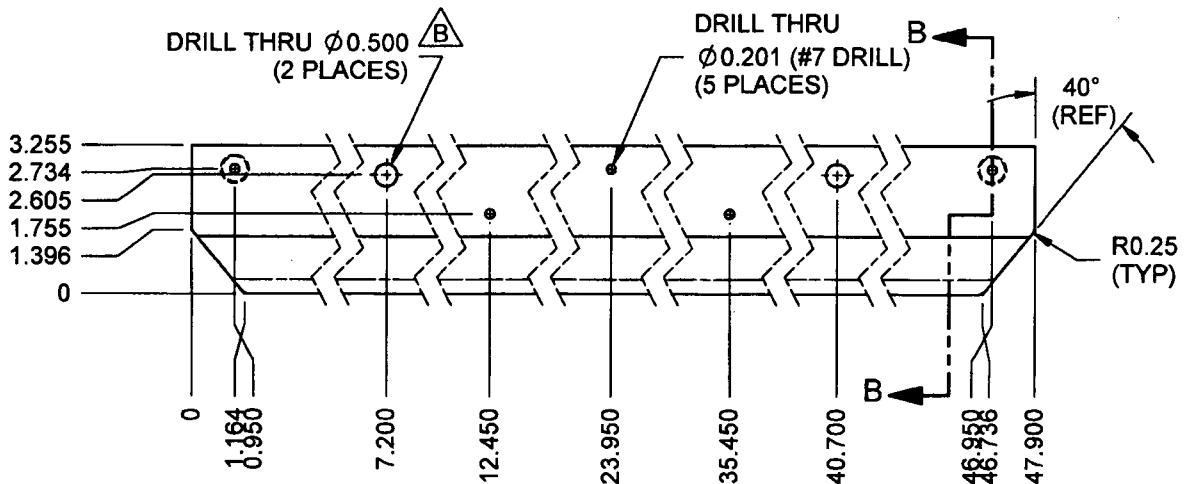
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 3 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4



RELEASED
06-10-2015



SECTION B-B



D3499-3 CABLE GUARD

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (UHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

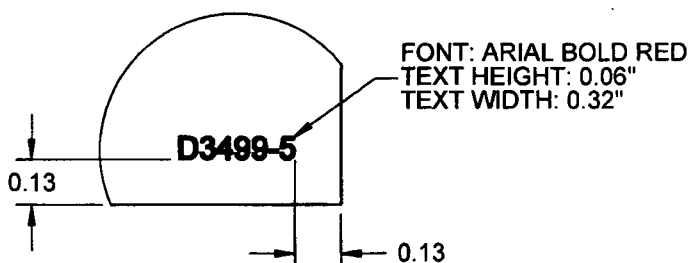
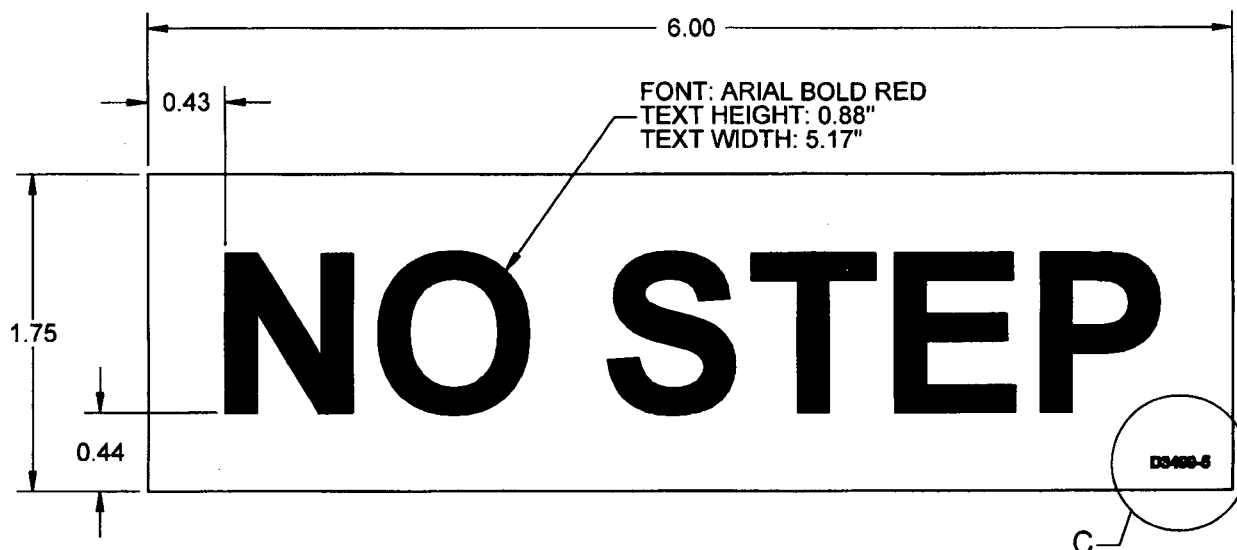
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NO. *144034*

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 4 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:1



DETAIL C
SCALE 1:2

D3499-5 PLACARD

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG x 1.75" WIDE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3-10 06 11/10

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